



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.4001

Job Sheet 200577



012300

Part No: 646.4001

Job Qty: 1 pcs

Part Name: AS350 Cable Cutter System



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/12/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/7/19

Description: ORDER 19439

Type: SOLD

Note: DWG REV C1 IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B
DD VERF:JLM IPP REV:C 16.01.07 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	10/7/19	10/7/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4	DAS 74	OCT 07 2019
							Packaging 1 - 5	9-89	
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S220562



Part: 646.4001

Job No: 200577

Serial No/Batch: S220562

Revision:

Inspector:

Exp Date: 03/05/2020

Instructions: FAA STC SR02180LA 14/08/07, T-C STC SH09 -

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120 QC 4	1 pcs	10/7/19	0.00 0.00	Packaging 1 - 31		
				Packaging 1 - 32		
				Packaging 1 - 33		
				Packaging 1 - 34		
				Packaging 1 - 35		
				Packaging 1 - 36		
				QC 4 - 28		
130 Packaging 3-1 - Stock - B4B	1 pcs	10/7/19	0.00 0.00	QC 4 - 58		
				QC 4 - 69		
				QC 4 - 9		
				QC 4 - 46		
				QC 4 - 68		
				QC 4 - 72		
				QC 4 - 74		
				QC 4 - 75		
				Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
135 DC - 1 - B4B	1 pcs	10/7/19	0.00 0.00	Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
140 QC 21 - FG	1 pcs	10/7/19	0.00 0.00	DC - 1 - B4B		
				DC - 2 - B4B		
				QC 21 - FG - 21		
140 QC 21 - FG	1 pcs	10/7/19	0.00 0.00	QC 21 - FG - 70		
				QC 21 - FG - 53		

DAS
78
9-89

OCT 15 2019

DAS
78
9-89

OCT 15 2019

OCT 16 2019

OCT 16 2019

DAS
70
9-89

Part Op 110 - pick kit

Descriptions: 120 - QC4- 100% Inspect kits for completeness

130 - Identify and pack for shipping as per PPP 646.4001 Location:

9/12/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

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135 - Document Control - Photocopy bluefile & type labels per PPP 646.4001

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600 0120	VHB Tape	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5158040
600 0590	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5157335
600 0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5157336
600 1012	Sealant (111225B2 #654 sem)	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5157116
600 1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5166242
646 2910	Deflector	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5195161
646 3001	Lower Cable Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5197148
646 3119	Channel	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5197331
646 3210	Support	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5197298
646 3301	Upper Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5208493
646 3510	Strut	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5187754
646 3511	Strut	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5183035
646 3610	Filler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5122257
646 3710	Doubler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5201667
646 3711	Clip	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5183057
646 3712	Clip	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5183061
646 3713	Gusset	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5190438
646 3714	Gusset	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5197814
646 3716	Strut Doubler	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5190147
646 3718	Gauge Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5192198
646 3717	Doubler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5190386
646 3718	Custom Washer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5202529
646 3719	Doubler	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5202485
646 3810	Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5190781
646 3811	Radius Block	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5196042
646 3812	Gusset Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5199359
646 3813	AS350 Strut Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5199353
646 3910	Shim	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5208528
646 3911	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5185805
646 3912	Shim	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5208530
646 3913	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5185803
646 3918	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5056098
647 0112	Strut Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5208465
647 7103	Strut Assembly	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5203054
6659 9201	Eyelet Bracket Assembly	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5175957
AN3-11A	Bolt	10 Ea (10 ea)	110-Packaging 1 - Pick Kit	516671948
AN3-12A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5166926
AN3-13A	Bolt	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5198032
AN3-3A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5203253
AN3-4A	Bolt	10 Ea (10 ea)	110-Packaging 1 - Pick Kit	5167263
AN3-5A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5149158
AN3-6A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5149175
AN31504R	Nut, Jam	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5198106
AN4-5A	Eyebolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5167576
AN407A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5142094
AN805-34R	Clevis	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5203154
CR2648S3-02	Cherry Rivet	35 Ea (35 ea)	110-Packaging 1 - Pick Kit	5156961
CR3213-5-3	Cherry Rivet	14 Ea (14 ea)	110-Packaging 1 - Pick Kit	5185286
MS20425AD5-7	Rivet	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5153848
MS20470AD5-5-5	Rivet	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5155675
MS20470AD5-6	Rivet	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5048897
MS26470AD5-7	Rivet	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5123425
MS21042L08	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5204283
MS21042L3	Nut	63 Ea (63 ea)	110-Packaging 1 - Pick Kit	5214467
MS21042L7	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	514214624
MS21047-3	Nut Plate	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5202072
MS21000-0270	Screw	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	

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MS24694-S51	Screw	1 Ea (5 ea)	110-Packaging 1 - Pick Kit	5133343
MS24694-S54	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5185070
MS24694-S55	Screw	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5142492
MS27039-08-13	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5123922
MS27039-1-10	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5157316
MS27039-1-12	Screw	6 Ea (6 ea)	110-Packaging 1 - Pick Kit	5174154x3 521496843
MS27039-1-16	Screw	24 Ea (24 ea)	110-Packaging 1 - Pick Kit	5159063
MS27039-1-19	Screw	22 Ea (22 ea)	110-Packaging 1 - Pick Kit	5156840x16 5216386x6
MS27039-1-20	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5182772
MS27039-1-21	Screw	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5107939
NAS1149F0312P	Washer (AN960-10L)	144 Ea (144 ea)	110-Packaging 1 - Pick Kit	5207709
NAS1149F0363P	Washer (AN960-10)	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5075330
NAS1149F0437P	Washer (AN960-416L)	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5214714
NAS1149F0532P	Washer (AN960-8)	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5191300

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	600.0129	8	263	0
	600.0990	1	15	0
	600.0991	1	14	0
	600.1012	1	11	0
	600.1013	5	35	0
	646.2910	1	11	0
	646.3001	1	11	0
	646.3110	1	17	0
	646.3210	1	11	0
	646.3301	1	11	0
	646.3510	1	21	0
	646.3511	1	20	0
	646.3610	1	14	0
	646.3710	1	27	0
	646.3711	1	13	0
	646.3712	1	17	0
	646.3713	1	17	0
	646.3714	1	20	0
	646.3715	2	17	0
	646.3716	1	31	0
	646.3717	1	26	0
	646.3718	2	31	0
	646.3719	2	12	0
	646.3810	2	21	0
	646.3811	1	21	0
	646.3812	2	14	0
	646.3813	1	27	0
	646.3910	4	16	0
	646.3911	1	18	0
	646.3912	4	22	0
	646.3913	1	14	0
	646.9410	1	51	0
	647.0112	2	30	0
	647.7703	2	16	0
	650.9201	2	11	0
	AN3-11A	10	151	0
	AN3-12A	2	146	0
	AN3-13A	1	29	0
	AN3-3A	4	187	0
	AN3-4A	10	281	0
	AN3-5A	2	38	0
	AN3-6A	2	288	0
	AN316C4R	2	28	0
	AN44-5A	2	21	0
	AN4C7A	2	67	0
	AN665-34R	2	32	0
	CCR264SS3-02	36	280	0
	CR3213-5-3	14	46	0
	MS20426AD5-7	2	671	0
	MS20470AD5-5-5	8	777	0
	MS20470AD5-6	8	614	0
	MS20470AD5-7	3	1,026	0

MS21042L08	2	964	0
MS21042L3	63	1,950	0
MS21042L4	2	1,490	0
MS21047-3	18	176	0
MS24693-C278	5	101	0
MS24694-S51	5	257	0
MS24694-S54	2	146	0
MS24694-S55	3	201	0
MS27039-08-13	2	355	0
MS27039-1-10	2	242	0
MS27039-1-12	6	130	0
MS27039-1-16	24	620	0
MS27039-1-19	22	205	0
MS27039-1-20	2	58	0
MS27039-1-21	4	119	0
NAS1149F0332P	144	2,000	0
NAS1149F0363P	2	352	0
NAS1149F0432P	4	318	0
NAS1149FN832P	4	2,159	0

Part Specifications

Specifications could not be found.

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Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



Job: _____					
Part No. _____					
DISPOSITION			DEPARTMENT / PROCESS		
Rework	Cross tube	Eng. (Non-AW)	Engineering		
Scrap	Small Fab	Prod. Eng. Coord.	Water Jet		
Use-as-is	Finishing	Rec./Store/Packaging	Supplier		
Date : _____			QTY Affected :		
Sequence #:			MRB (QSI042)		
Description Work Order Deviation			Disposition		
Completed By					
Lead hand / Supervisor					
QC / QA Coordinator					
Root Cause					
Operator	Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	
Manufacturing Process	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	
Equip/Tooling	Crushing	BOM/Route	Grain Direction	Drawing	
Handling/Preservation	Cracks	Broken/Damage/Defect	Weld	Finish	
Material	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	
Product Improvement	Marks/Chatter	Drill Holes	Out of Sequence	Misread	
Process Improvement	Mislabeled	Fit/Function	Off-set/Set-up		
Human Factors	Other/Details:				

THE 2ND VARIOUS... 1 2

DBA IN AEROSOL... 1 2

W/IN PER... 1 2

NOTES:

1. AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND RILET EDGES.
2. INSTALL F/N 14 WITH F/N 52 & 53.
3. 3M VHB ADHESIVE TAPE .003" THICK, 1" TO 2" WIDE
VENDOR: MCMMASTER-CARR / F/N 759364&51.
4. 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
VENDOR: 3M, HUGHES F/N 021260-24016.
5. REUSE FASTENERS FROM F/N 1.
6. USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.
7. AT CUSTOMERS OPTION, INSTALL F/N 40 BY MATCH DRILLING ON TO F/N 1.
8. INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON A "CRAFT, REMOVE SHIM LAYERS TO ACHIEVE CORRECT FIT. MATCH DRILL HOLES, USE F/N 71 TO SCREW IN PLACE OF F/N 17 SCREW.
9. NEWER INSTALLATION ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS, USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

UNINCORPORATED(S)

S	QTY	PART #	DESCRIPTION	WAS.	SPEC.
5	5	76	SCREW		
1	1	77	SHIM		
	4	76	WASHER		
	2	75	LOCKNUT		
	2	74	SCREW		
	2	73	LOCKNUT		
	2	72	NUT		
	2	71	LOCKNUT		
	4	70	WASHER		
	2	69	BOLT		
	2	68	CLEVIS		
	2	67	EYE BOLT		
	2	66	EYE BRACKET ASSY		
REF:	R	65	GPMOUNT KIT		
	4	64	WASHER		
	2	63	SCREW		
	2	62	SCREW		
	1	61	BOLT		
	4	60	SHIM		
	1	59	SHIM		
	4	58	SHIM		
	4	57	SHIM		
	5	56	PRIMER		
	8 FT	55	VHB TAPE		
	1	54	SEALANT		
	1	53	MACH X-1 AND ASST PARTS		
	1	52	MAGHOLAND ASSEMBLY A		
	10	51	BOLT		
6	2	50	TIPPER BRACKET		
	2	49	SCREW		
	2	48	SCREW		
	2	47	DOUBLER		
	2	46	CUSTOM WASHER		
1	22	45	COLLIER		
	2	44	SCREW		
	2	43	SCREW		
	4	42	SCREW		

[illegible][illegible]